

Date: Thursday, 12/14/2006 3:46:11 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARSHOE
Job Number	: 29976		
Estimate Number	: 10314		
P.O. Number	: <i>N/A</i>	Part Number	: D265613
This Issue	: 12/14/2006 S.O. No. : <i>N/A</i>	Drawing Number	: D2656 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : SMALL / MED FAB	Drawing Revision	: D
Previous Run	: 29009	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 1/5/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	30 Um: Each
Comment	Est: <i>[Signature]</i> 02.10.25 Re-format KJ/RF Est Rev:G Now on Waterjet 06-07-03 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S20GA	1010/1025/A21/6aA SHEET
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Comment: Qty.: 0.5367 sf(s)/Unit Total: 16.0997 sf(s)

1010/1025/A21/6aA SHEET

20 gauge

Batch:

*M101463(15)**M103220(13)**M103258 (2)**(30)*

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D 2656

Dwg Rev: *D*Prog Rev: *2**SAD 07/02/05 (30)*

2-Deburr if necessary

SAB 07/02/06 (30)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/02/05 (30)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

MAD 07/02/05 (30)

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

1-Form on Brake as per Dwg D2656 using Jigs DT8261 and DT8326

2-Form joggle as per Dwg D2656 using Jig DT8158 Identify as D2656-13

SAD 07/02/08 (30)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: RD Date: 07/02/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Thursday, 12/14/2006 3:46:11 PM
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Process Sheet

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Drawing Name: WEARSHOE

Job Number: 29976

Part Number: D265613

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



20702-0830



Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



M1101601



(30x)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSi 005 4.3

M.B. / YL

07/02/09

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

YL 07/02/09 (30)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *FP21*

YL

07/02/09 x.30

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(30)

Comment: FINAL INSPECTION/W/O RELEASE

07/02/09

Job Completion



U 070209

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

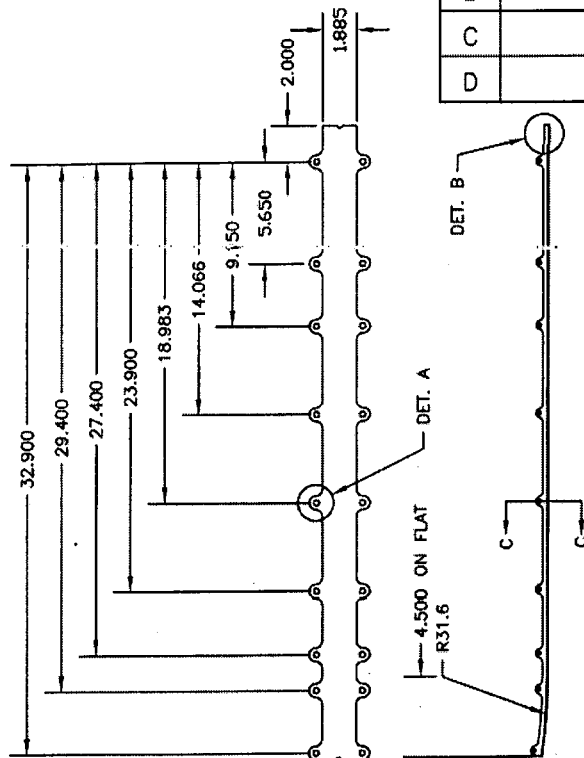
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

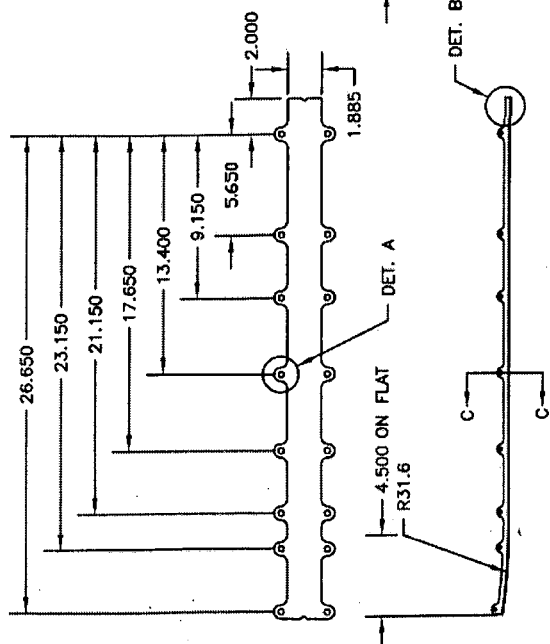


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				PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	REV: D
				D2656	SHEET 1 OF 4
DATE	05.08.17			TITLE	SCALE
				WEARSHOE	1:10
A	97:03:25			NEW ISSUE	
B	97:06:02			CHANGED TABS	
C	97:06:26			R31.6 WAS R19.5	
D	05.08.17			ENLARGE ALL HOLES TO IMPROVE FIT	

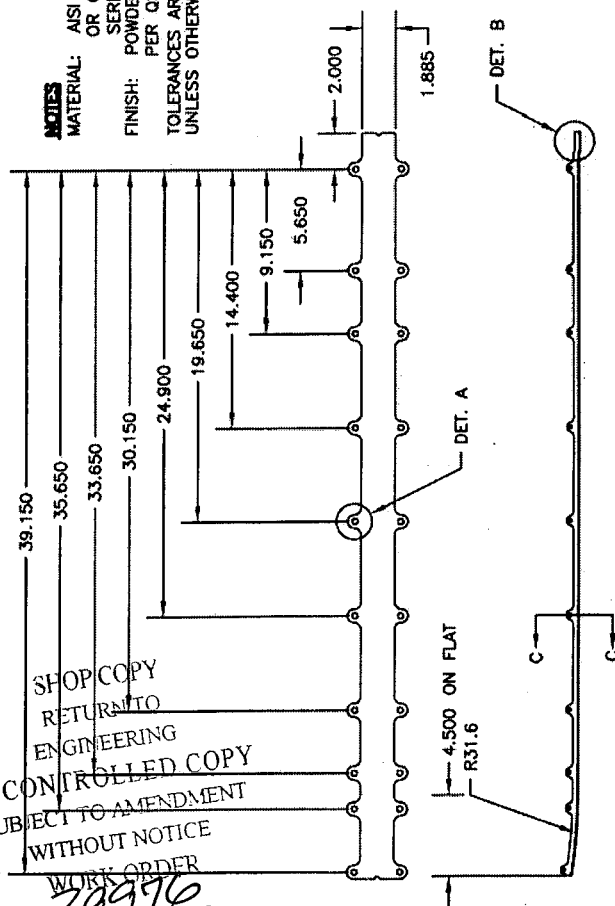
D2656-13



D2656-11



D2656-15



NOTES
 MATERIAL: AISI 1010-1025 OR ASTM A313/A366/A1008
 OR CSA C40-21, 38W/44W/53W/60W/70W
 SERIES STEEL 20 GAUGE (0.040 THICK)
 FINISH: POWDER COAT GREY SANDTEX (2.3.5.6)
 PER QSI 005 4.3
 TOLERANCES ARE PER DART QSI 018
 UNLESS OTHERWISE NOTED

RELEASED
 05.08.17

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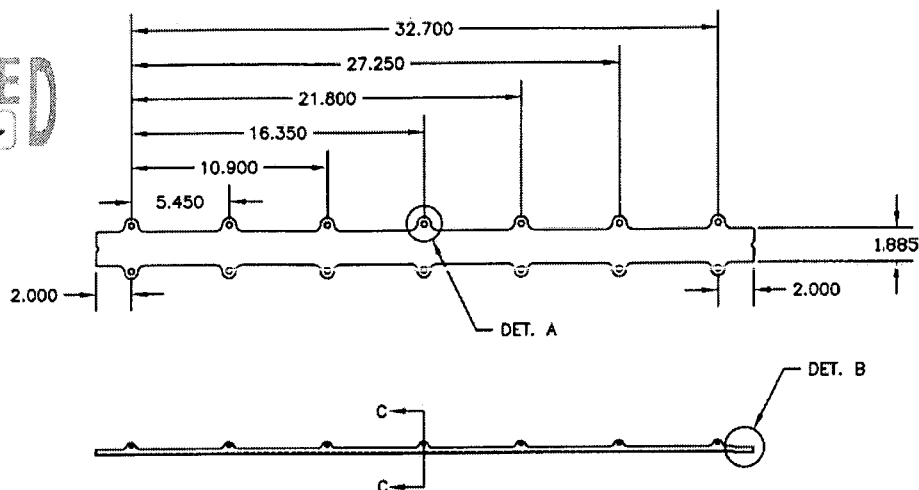
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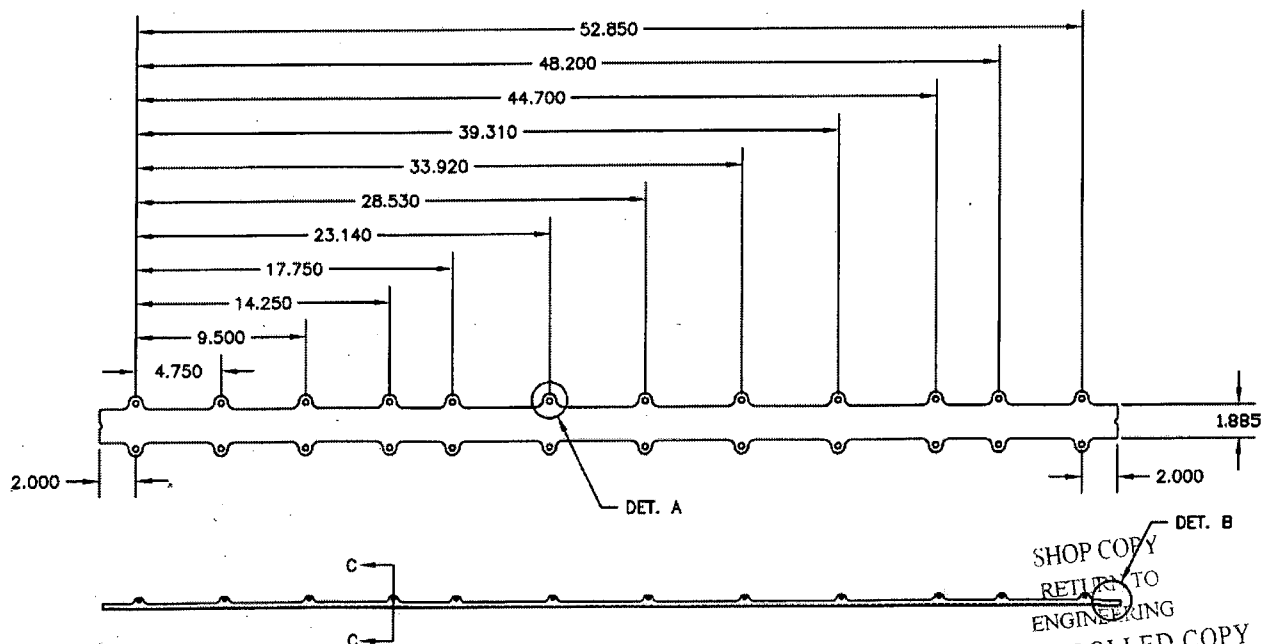
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DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

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D2656-21



D2656-23



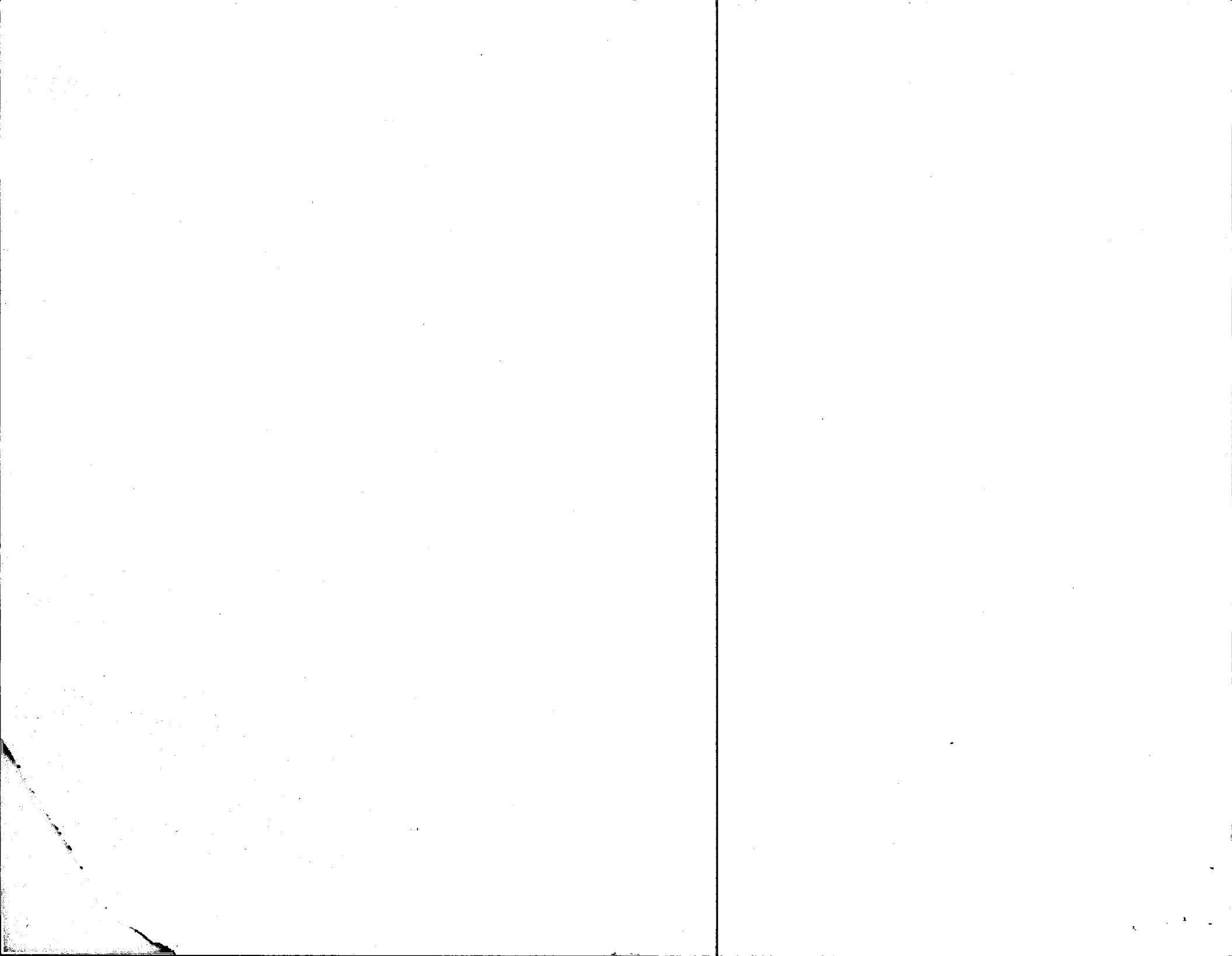
NOTES

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SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

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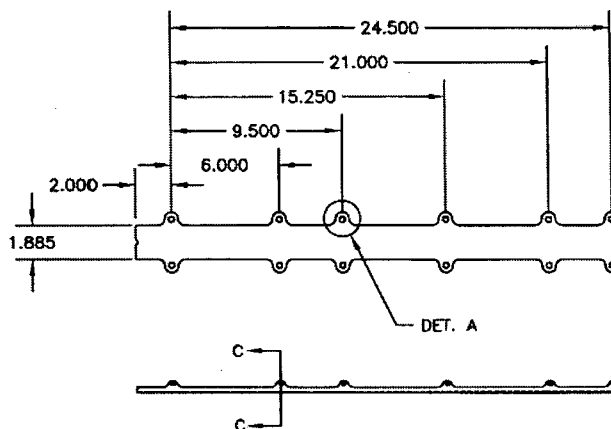
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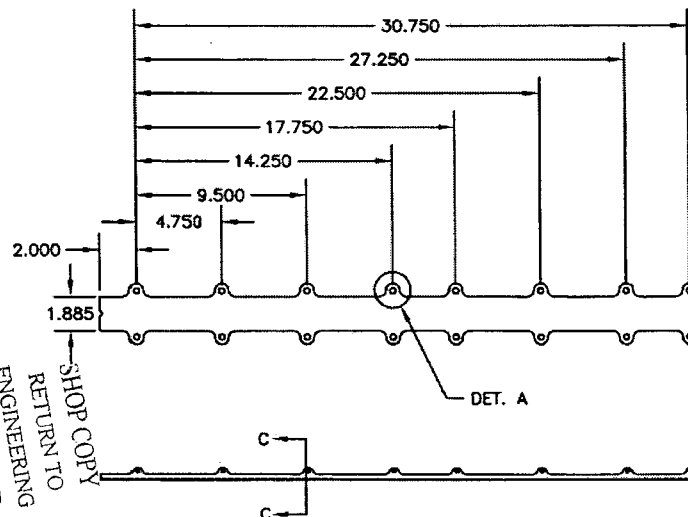
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DATE	05.08.17	TITLE	WEARSHOE	REV. D
		DRAWING NO.	D2656	SHEET 3 OF 4
		SCALE	1:10	

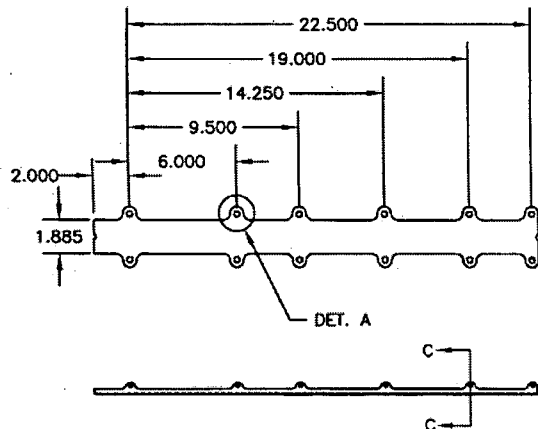
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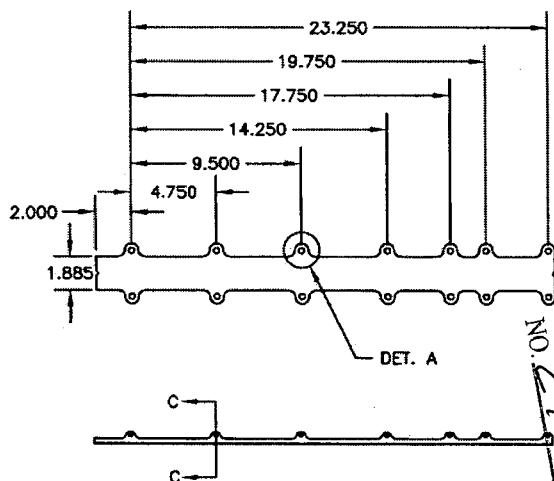
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D2656-31



D2656-35



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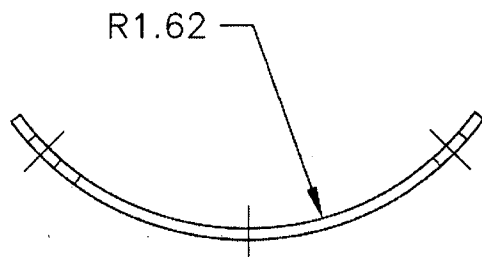
NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
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FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
TOLERANCES ARE PER QSI 018
UNLESS OTHERWISE NOTED



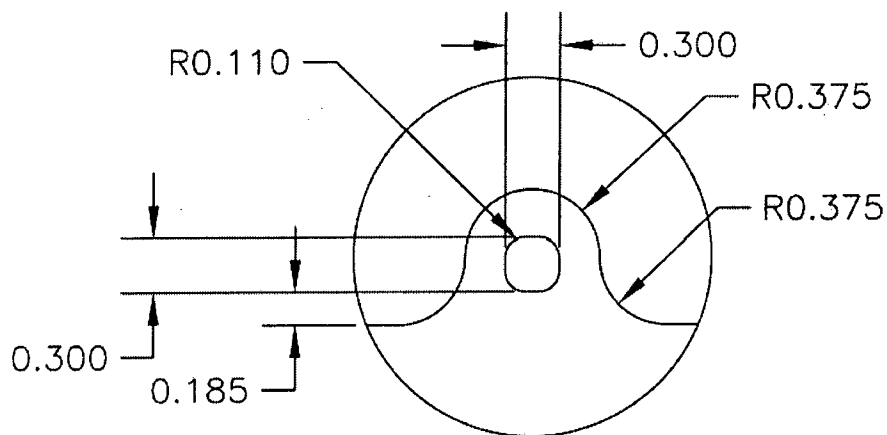
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DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

SECTION C-C

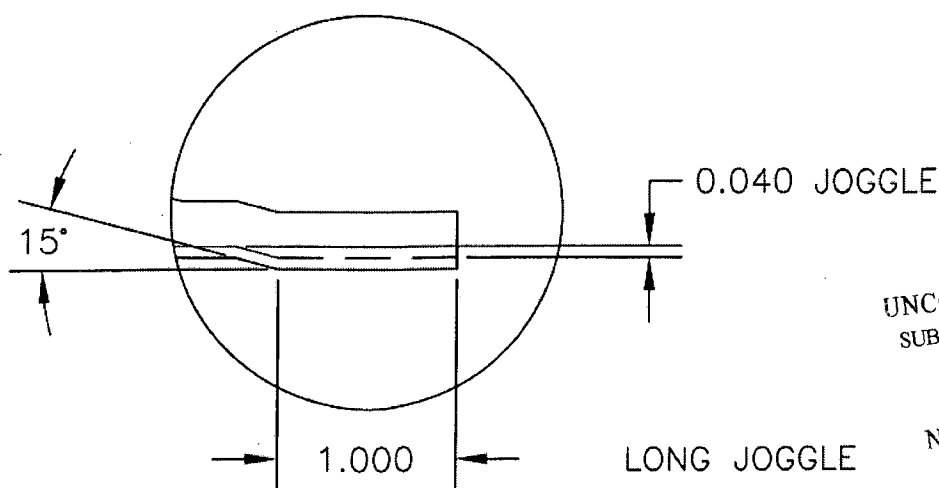


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DETAIL A



DETAIL B



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DART AEROSPACE LTD		Work Order:	29976
Description:		Part Number:	D265613
Inspection Dwg:	Rev:	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

[illegible]

Measured by:	SAD	Audited by:	AS	Prototype Approval:	N/A
Date:	07/02/05	Date:	07/02/05	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

